

ABSTRACT OF THE DISCLOSURE
A METHOD OF FABRICATING COMPOSITE TUBULAR DOOR FRAME

5 A method of fabricating composite tubular door frame is disclosed.
The method comprises the steps of laying-up a plurality layers of prepreg
composite fabrics on a mould having an upper mould component and a
lower mould component, and each layer of the composite fabric being
10 compacted; placing a plurality of nylon tubes over the composite fabric at
the upper mould component with the ends of the nylon tubes being
extended out at each of the corners of the mould to be sealed with a main
bag placed over the top and envelope the upper mould component;
proceeding the mould to a curing step with a curing pressure of 4 to 7 bars
15 with 0.3 to 0.7 bar vacuum, the mould being heated in an autoclave to 80
degree C and hold for 30 min. to 1.5 hour with 0.3 to 0.7 bar of vacuum in
the enclosure enveloped the main bag sealed with the nylon tubes; and
removing the main bag from the mould and the nylon tubes being pulled out
of from the mold and removing the mould to obtain a tubular door frame.
Excess composite fabric is trimmed off from the fabricated tubular door
20 frame.

(FIG. 3 (a))